

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020816**Date Inspected:** 08-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Chang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

**OBG Segment 9BE**

Flux Core Arc Welding (FCAW) in the 2G position of FL3 Half Diaphragm, weld # SSD27-PP075-174. The welder is identified as 222396. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with B-P-2232-B-U2-F.

**OBG Segment 9BE-9CE**

During in process visual inspection of 9BE-9CE, This QA Inspector observed ABF Quality Assurance (QA) personnel Mr. Ding performing Ultrasonic Testing (UT) on Cross Beam Edge Panel Splice weld joint. See attached photograph Pic\_001

**OBG Segment 9AW-9BW**

Flux Core Arc Welding (FCAW) in the 3G position of Side Panel Splice weld at Cross Beam side, weld # OBW9B-004/005. The welder is identified as 045280. ZPMC Quality Control (QC) is identified as Shi Lei. The

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welding variables recorded by QC appeared to comply with WPS B-T-2233-B-U2-F. See attached photograph Pic\_002

### OBG Segment 9BE

Shielded Metal Arc Welding (SMAW) in the 2G position of FL3 Half Diaphragm, weld # SSD27-PP075-029. The welder is identified as 048659. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS B-P-2212-B-U2a-1.

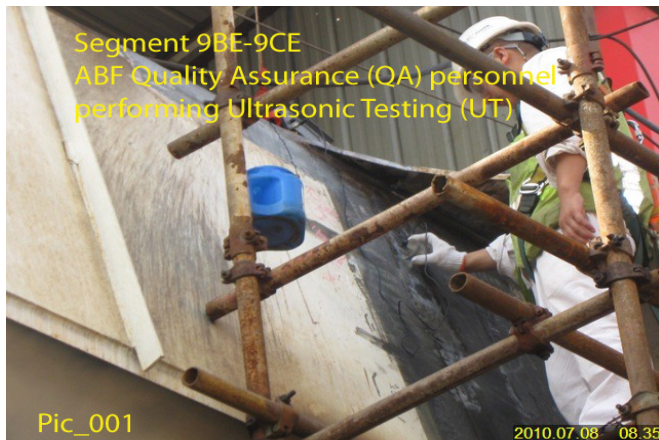
### OBG Segment 9AW-9BW

During in process visual inspection of 9AW-9BW, This QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Side Panel 'T' Ribs holdback area of Counterweight side.

### OBG Segment 9AW

This QA inspector performed Magnetic Particle Ultrasonic Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as BP to SP – W4 weld repaired area as per ABF notification # 07072010-1

The weld designations reviewed are as follows:  
SEG049A-014



### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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